

AN 1997-285332 [26] WPIDS  
DNC C1997-091988  
TI **Steel** sheet mfr. for production of cans - comprises rolling,  
**cooling** and pickling under specified conditions a **steel**  
sheet containing manganese and niobium.  
DC M24 M27  
PA (KAWI) KAWASAKI STEEL CORP  
CYC 1  
PI JP 09104919 A 19970422 (199726)\* 8  
ADT JP 09104919 A JP 1995-258964 19951005  
PRAI JP 1995-258964 19951005  
AB JP 09104919 A UPAB: 19970626

The **steel** sheet is made by **rough rolling** a  
**steel** slab including (by weight): up to 0.0050% C, up to 0.010% Si,  
0.050-1.50% Mn, up to 0.010% P, up to 0.015% S, up to 0.0050% N and up to  
0.150% Al and 0.0030-0.020% Nb, **coiling** the obtained sheet to  
hold the heat, heating the edge portions of the unwound sheet bar,  
**finishing rolling** with a termination temperatures of  
(Ar3 pt. + 50 deg. C) to (Ar3 - 50 deg. C), air **cooling** it for  
at least 2 seconds, water **cooling** it with a mean rate of up to  
100 deg. C/second while masking is applied so that at least one of top and  
bottom **cooling** water does not impinge the edge portions of the  
**steel** sheet in hot line **cooling**, **coiling** it at  
600-759 deg. C. acid pickling, cold rolling with reduction of 80-98% and  
annealing the sheet at temperatures of at least the recrystallising  
temperatures.  
Dwg.0/0